

Work Order ID 142623

Friday, March 11, 2016 9:56:57 AM

646.9603

B142623

REV. N/C

142623

Page 1

Item ID: 646.9603

Revision ID:

Item Name: Lower Cutter Assy Low

Start Date: 4/11/2016 Start Qty: 2.00

Required Date: 4/22/2016 Req'd Qty: 2.00

Reference:

Accept

N900040100

Setup Start *NS1*

Stop *NS2*

Cust Item ID:

Customer:

Approvals: Process Plan: MLJ Date: MAR 11 2016 Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start *NR1*

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
646.9600	N/C								

110 Pick Kit 0.00

110

Packaging Memo 0.00

Packaging

DAS
36
9-89

APR 13 2016

120 0.00

120

Small Fab Memo 0.01

Small Fab

Assemble as per dwg and apply loctite 598 on all faying surfaces per note 2.

A/R RTV LOCTITE 598: M134524
exp. date: 09/17

DAS
36
9-89

16/05/24

130 QC5- Inspect part completeness to step on W/O 0.00

130

QC Memo 0.00

Quality Control

(2)

DAS
38
9-89

MAY 25 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QS1042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	
Description Work Order Deviation		Disposition			
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
		OTHER :			

Work Order ID 142623

Friday, March 11, 2016 9:56:57 AM

142623

Page 2

Item ID: 646.9603

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Lower Cutter Assy Low

Start Date: 4/11/2016 Start Qty: 2.00

2

Cust Item ID:

Required Date: 4/22/2016 Req'd Qty: 2.00

2

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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140

Identify as per dwg & Stock Location: CC1030 0.00***140***

Packaging

Memo

0.00

MAY 2 5 2016

20.00

Packaging

IDENTIFY AS PER IAW MPP-120

150

QC21- Final Inspection - Work Order Release 0.00

150

QC

Memo

0.00

MCJ

MAY 2 5 2016

Quality Control

MCJ

MAY 2 5 2016

DQA: _____ Date: _____



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Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : ☐					

Picklist Print

Friday, March 11, 2016 9:56:56 AM

Page 1

Work Order ID: 142623

142623

Parent Item: 646.9603

646 9603

Parent Item Name: Lower Cutter Assy Low

Start Date: 4/11/2016

Required Date: 4/22/2016

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP REV:A 12.08.13 NEW ISSUE DD VERF:JFS

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
646.9701 *646 9701* Cutter Sub Assembly		Manufactured	No			110	Each	8.0000	1	2		DAS 6 9-89	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				cck012		8							
				141900		8				2			
646.9813 *646 9813* Lower Deflector Low		Manufactured	No			110	Each	1.0000	1	2		DAS 6 9-89	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				CCK106		1							
				125263		1							
MS21042L08 *MS21042L 08* Nut		Purchased	No			110	Each	1,645.000	3	6		DAS 6 9-89	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				CA		101							
				m129682		101							
				GA		161							
				m133134		3							
				m134063		158							
				OVER007		500							
				m134063		500							
				ST303		483							
				m133922		483				6			
				ST308		400							
				m134376		400							

APR 13 2016

APR 13 2016

DQA: _____ Date: _____



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Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
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Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabelled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
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Picklist Print

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Page 2

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142623

Parent Item: 646.9603

646 9603

Parent Item Name: Lower Cutter Assy Low

Start Date: 4/11/2016

Required Date: 4/22/2016

Start Qty: 2.00

Required Qty: 2.00

MS27039-08-19

Purchased

No

110

Each

1,040.000

3

6

MS27039-08-19

Screw



Location

Loc Qty

Loc Code

CCK06

200

m134142

200

GA

677

m132930

84

m133077

22

m134063

571

over006

100

m134294

100

ST277

63

m133769

63

NAS1149FN832P

Purchased

No

110

Each

3,671.000

6

12

NAS1149FN832P

Washer



Location

Loc Qty

Loc Code

GA

1361

M133316

16

M133769

1345

ST260a

1200

M134257

1200

ST262

1110

M133709

1110

APR 13 2016

DQA: _____ Date: _____



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Date :	Step #:	QTY Effective :		MRB (QS1042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER :					

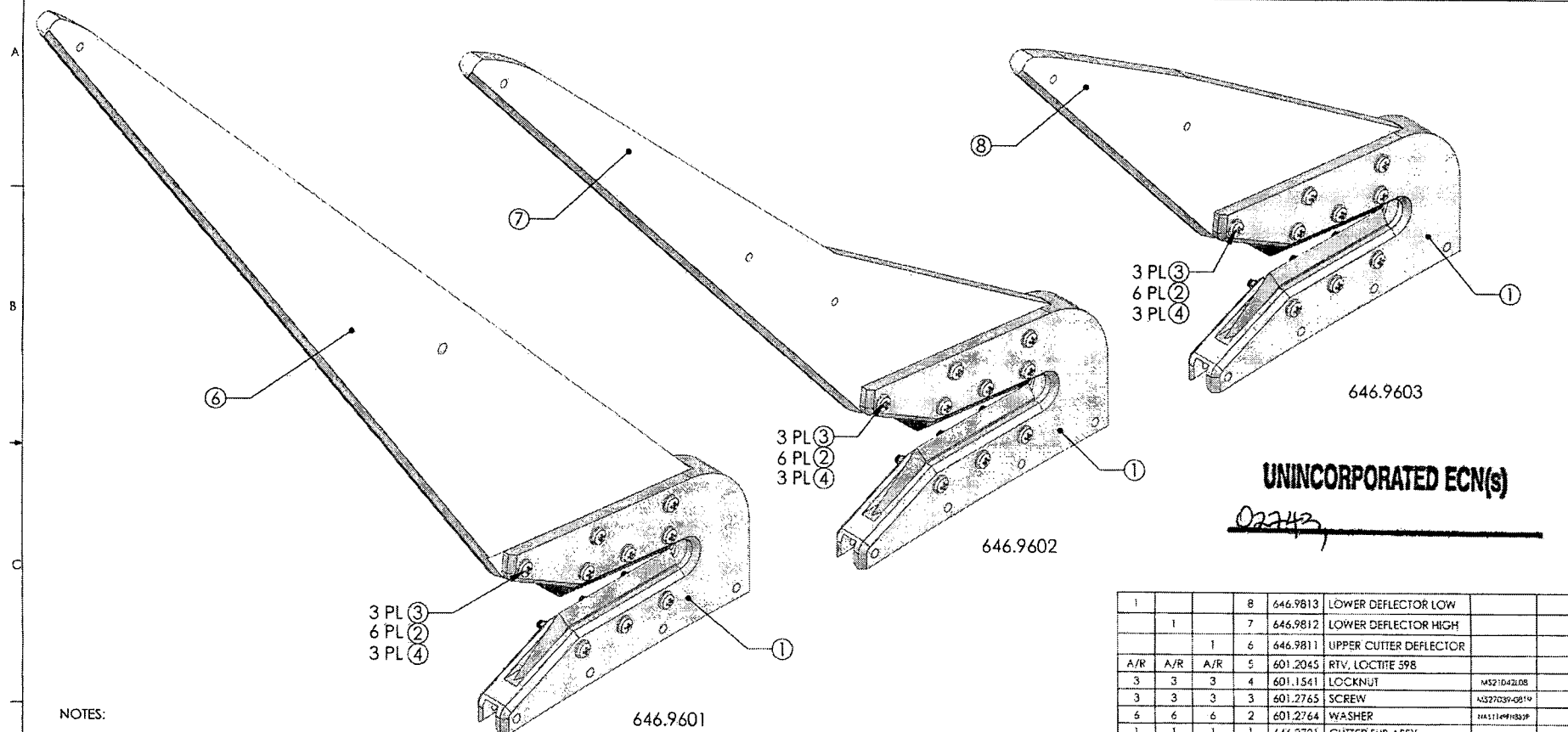
APICAL INDUSTRIES, INC.	ENGINEERING CHANGE NOTICE NO. 02743				SHEET 1 OF 1	
	DWG NO. 646.9600	REV: N/C	PREPARED BY S. HUFF	DATE: 01/07/10	EFFECT ON DWG ☐ INC. ☒ UNINC.	
	DWG TITLE: CUTTER ASSY					
APPROVED BY:		ENGR <i>P. Bravo</i>	MFG <i>Amel Gonyer</i>	QC <i>Maia Lopez</i>	EFF: NEXT ORDER	
TRANSACTION CODES (TC): A-ADD C-CREATE R-REVISE D-DELETE		REASON: REVISED SCREW LENGTH.				

SHOP COPY
 RETURN TO
 ENGINEERING
 UNCONTROLLED COPY
 SUBJECT TO AMENDMENT
 WITHOUT NOTICE
 WORK ORDER
 NO. 142623 MW
 16-03-11

3	R	601.3157	3	3	3	SCREW	MS27039-0818
			.9603	.9602	.9601		
F/N	TC	PART NUMBER	QTY		DESCRIPTION		MATERIAL/SPECIFICATION
DOCUMENTS EFFECTED: ☐ MDL ☐ INSTALL INSTRU ☒ ICA ☐ FMS ☒ BOM							CHANGE CATEGORY ☐ MAJOR ☒ MINOR
DER REVIEW REQUIRED ☐ YES ☒ NO							

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REVISIONS			
REV.	DESCRIPTION	DATE	APPROVED
1	LAST PROTOTYPE REVISION #1		PLC
2	INITIAL RELEASE	04/20/09	P. BRAYO



UNINCORPORATED ECN(s)

02243

NOTES:

1. IDENTIFY IAW MPP-120
2. APPLY F/N 5 AS REQUIRED TO ALL FAYING SURFACES OF F/N 1, 6, 7, & 8 UPON ASSEMBLY

1			8	646.9613	LOWER DEFLECTOR LOW		
	1		7	646.9612	LOWER DEFLECTOR HIGH		
		1	6	646.9611	UPPER CUTTER DEFLECTOR		
A/R	A/R	A/R	5	601.2045	RTV, LOCTITE 598		
3	3	3	4	601.1541	LOCKNUT	M52-1042L08	
3	3	3	3	601.2765	SCREW	A327039-08/14	
6	6	6	2	601.2764	WASHER	M4X11X.49/150ZP	
1	1	1	1	646.9701	CUTTER SUB ASSY		
X	X	X		646.9603	LOWER CUTTER ASSY LOW		
				646.9602	LOWER CUTTER ASSY HIGH		
				646.9601	UPPER CUTTER ASSY		
.9603	.9602	.9601	FIND #	PART #	DESCRIPTION	MAT'L	SPEC.
QTY				PARTS LIST			
NEXT ASSY (S)				ORIGINAL DATE			
646.9500				DRAWN BY: 1. JACKSON			
				CHECKER: P. BRAYO			
				DRAWING APPROVAL: (B)			
				REVISION: (B)			
				CORRECTION (R)			
				UNLESS OTHERWISE SPECIFIED			
				DIMENSIONS ARE IN INCHES			
				TOLERANCES ARE:			
				FRACTIONS DECIMALS ±.01			
				3 PLACE DECIMALS ±.005			
				ANGLES ±.1°			
				UNLESS OTHERWISE SPECIFIED			
				DIMENSIONS ARE IN INCHES			
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